

Date: Wednesday, 10/10/2007 10:59:49 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LH STEP ACTUATOR ASSEMBLY
Job Number : 35059	
Estimate Number : 12758	
P.O. Number : N/A	Part Number : 41232 000 001 001
This Issue : 10/10/2007 S.O. No. : N/A	Drawing Number : 41232-000-001 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 31743	Material : N/A
Written By : <u>HA</u>	Due Date : 10/30/2007 Qty: 1 Um: Each
Checked & Approved By : <u>HA 071010</u>	
Comment : Est Rev:A New Issue 07-02-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP41232-000-001 CHG 001

22/01/17

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	AP0925ELBN	BARBED ELBOW
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BARBED ELBOW

Batch: M103727-

CPS.

4.0	AN960JD416	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M104746-

5.0	MS21042L4	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut

Batch: M104683-

CPS. 27/10/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

AN423A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bolt
Batch: M103688

7.0

MS3548993

GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GROMMET
Batch: M105792

8.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: M105408

9.0

MS24665151

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cotter Pin
Batch: M14526

10.0

MS203923C21

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pin
Batch: M104156

11.0

R 3400

plastic tubing 1/4id x 3/8od-black



Comment: Qty.: 3.0500 f(s)/Unit Total : 3.0500 f(s)
plastic tubing 1/4id x 3/8od-black
Cut to 18" Long X2
Batch: M104229

12.0

41232 200 006 001

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket
Batch: 3 30505

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

41232 200 005 001

Spacer (Step Actuator)



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Spacer (Step Actuator)
Batch: 330503

CP.



14.0

41232 200 004 001

Reducer Tee Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Reducer Tee Assembly
Batch: B31779

CP



15.0

41232 200 003 001

Spring (Step Actuator)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spring (Step Actuator)
Batch: B30941

CP.



16.0

41232 200 001 001

Step Actuator LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Step Actuator LH
Batch: B35181

*

AS 08/01/17

(XU)

17.0

124K002 4CR 0545

Hose ass'y-Step Actuator



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hose ass'y-Step Actuator
BATCH: M104384

CP



18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

CP 07/10/15 @
08/01/17 (XU)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP 41232-000-001-001

Location: B

PPP Rev: 8/1/17

SD

(17)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					/		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/01/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



(7)

Comment: FINAL INSPECTION/W/O RELEASE

2008/01/18

Job Completion



2008/1/17
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REVISION					
LETTER	DTSMAN	DATE	DESCRIPTION	APPROVED	DATE
A	DNN	1/14/04	INCCORP. E.O.; CHG. P/N OF ITEM #17. MINOR CHANGE - FAR 21.95	1/20/04-1-1	1/14/04

(A)				1	1	17	PS4025E000DF540A	HOSE							
				1	1	16	AP0925ELBN	BARBED ELBOW	ARK-PLAS PRODUCTS, INC., FLIPPIN, ARKANSAS 72634						
				2	2	15	AN960JD416	WASHER							
				1	1	14	MS21042-L4	NUT							
				1	1	13	AN4-23A	BOLT							
			AR	AR		12	MIL-S-8802	SEALANT							
				1	1	11	MS35489-93	GROMMET							
				2	2	10	AN960JD416L	WASHER							
				1	1	9	MS24665-151	COTTER PIN							
				1	1	8	MS20392-3C21	PIN							
				2	2	7	R-3400 1/4 ID x 3/8 OD BLACK	PLASTIC TUBING	NORTON PERFORMANCE PLASTICS CORP., AKRON, OHIO 44309						
				1	1	6	41232-200-006-001	BRACKET	(ALT. P/N 412-050-026-101, BELL HELICOPTER)						
				3	3	5	41232-200-005-001	SPACER							
				1	1	4	41232-200-004-001	REDUCER TEE							
				1	1	3	41232-200-003-001	SPRING							
				1		2	41232-200-001-002	R/H ACTUATOR ASSY							
					1	1	41232-200-001-001	L/H ACTUATOR ASSY							
							-002	R/H INSTALLATION							
							-001	L/H INSTALLATION							
							-002	-001	END NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC	ZONE

NO. REQ'D PER ASSY

LIST OF MATERIAL

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41232-1000

NEXT ASSEMBLY

UNLESS OTHERWISE SPECIFIED
X ±.1
XXL ±.03
XXXL ±.010
ANGLES
±.1°

DRAFTSMAN	D. NELSON	5/20/02
CHECK	D. MURPHY	5/20/02
STRESS		
PROJ. ENGR.		
HEAT TREAT		
FINISH		

TITLE	STEP ACTUATOR INSTALLATION	
DWG. SIZE	C	SCALE
DWG. NO.	41232-000-001	REV.
SHT	1 OF 2	A

Eva Aviation, Inc.

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